

Work Order ID 72389

Monday, July 25, 2011 9:18:37 AM



Page 1

Item ID: D412-682-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Beam

Start Date: 7/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-07-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D412-682

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD412-682-001

CHG001

[Signature] 11 07 26 (2)

130

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

Pick Packing Kit ☐ *****Ensure original Bell ARC and Tags are packaged in kit*****

11/7/25 *[Signature]* (2)

140

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

[Signature] 11 07 26 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD412-682-001 Location: _____ PPP Rev: _____								
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/7/26 (2)

11/7/26 (2)

11-07-24 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 9:18:43 AM

Page 1

Work Order ID: 72389

Parent Item: D412-682-001

Parent Item Name: Support Beam

Start Date: 7/25/2011

Required Date: 8/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 08.03.19 new issue EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

604-028-001

Purchased

No

110

Each

2.0000



2

412 Bolt (412-050-008-101)

Location

Loc Qty

Loc Code

ST377

2

111580

2

110

Each

2.0000



2

604-030-001

Purchased

No

412 Rocker beam (412-050-003-109)

Location

Loc Qty

Loc Code

ST186

2

118310

2

110

Each

38.0000



2

AN320-8

Purchased

No

Nut

Location

Loc Qty

Loc Code

ST324

38

106552

38

110

Each

103.0000



2

MS24665-285

Purchased

No

Cotter Pins

Location

Loc Qty

Loc Code

ST309

103

9003

103

2

11/7/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Monday, July 25, 2011 9:18:43 AM

Work Order ID: 72389

Parent Item: D412-682-001

Parent Item Name: Support Beam



Start Date: 7/25/2011

Required Date: 8/25/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0832P

Purchased

No

110

Each

255.0000



WASHER



SL 11/7/25 (2x)

x2

Location

Loc Qty

Loc Code

ST275

255

18057

255

2

Monday, July 25, 2011 9:18:43 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

LANDING GEARS KITS (HIGH)

Qty -001	Qty -011	Qty -011B	Qty -013	Qty -015	Qty -021	Qty -025	Qty -035	Part Number	Description
X								D412-682-001*	SUPPORT BEAM KIT
	X							D212-682-011	LANDING GEAR KIT HIGH, 205/210/212
		X						D212-682-011B	LANDING GEAR KIT HIGH, 214
			X					D212-682-013	LANDING GEAR KIT HIGH, 204
				X				D412-682-015	LANDING GEAR KIT HIGH, 412
					X			D212-682-021	LANDING GEAR KIT, 205/210/212, APICAL FLOAT COMPATIBLE
						X		D412-682-025	LANDING GEAR KIT, 412, APICAL FLOAT COMPATIBLE
							X	D412-682-035	LANDING GEAR KIT, 412, OEM/APICAL FLOAT COMPATIBLE
	1		1	1	1	1	1	D212-664-101	CROSSTUBE FWD HIGH, 204/205/210/212/412
		1						D212-664-101B	CROSSTUBE FWD HIGH, 214
	1		1		1			D212-664-201	CROSSTUBE AFT HIGH, 204/205/210/212
		1						D212-664-201B	CROSSTUBE AFT HIGH, 214
				1		1	1	D412-664-203	CROSSTUBE AFT HIGH, 412
	2	2		2				D205-634-011	SKIDTUBE, 205/210/212/214/412
			2					D204-635-011	SKIDTUBE, 204
							2	D412-742-011	FLOAT SKIDTUBE, OEM/APICAL, 412
					2	2		D412-742-013	FLOAT SKIDTUBE, APICAL, 205/210/212/412
1 /								412-050-003-113	SUPPORT BEAM ASSEMBLY (OR AAI P/N 604-030-001)*
1 /								412-050-008-101	BOLT (OR AAI P/N 604-028-001)
1 /								AN320-8	NUT
1 /								MS24665-285	COTTER PIN (OR AN380-3-4)
1 /								NAS1149F0832P	WASHER

LANDING GEARS KITS (STANDARD AND LOW NARROW)

Qty -111	Qty -111B	Qty -113	Qty -115	Qty -117	Part Number	Description
X					D212-682-111	LANDING GEAR KIT STANDARD, 205/210/212
	X				D212-682-111B	LANDING GEAR KIT STANDARD, 214
		X			D212-682-113	LANDING GEAR KIT STANDARD, 204
			X		D412-682-115	LANDING GEAR KIT STANDARD, 412
				X	D412-682-117	LANDING GEAR KIT LOW NARROW, 412
				1	D412-664-105	CROSSTUBE FWD LOW NARROW, 412
1		1	1		D212-664-107	CROSSTUBE FWD STANDARD, 204/205/210/212/412
	1				D212-664-107B	CROSSTUBE FWD STANDARD, 214
				1	D412-664-205	CROSSTUBE AFT LOW NARROW, 412
1		1			D212-664-207	CROSSTUBE AFT STANDARD, 204/205/210/212
	1				D212-664-207B	CROSSTUBE AFT STANDARD, 214
			1		D212-664-209	CROSSTUBE AFT STANDARD, 412
2	2		2	2	D205-634-011	SKIDTUBE, 205/210/212/214/412
		2			D204-635-011	SKIDTUBE, 204

CUSTOMERS REQUESTING THE ARMOR SHIELD OPTION ON CROSSTUBES SHOULD ORDER THE ABOVE CROSSTUBE/LANDING GEAR KITS WITH AN "A" EXTENSION.

IE. D212-664-101 CROSSTUBE WITH ARMOR SHIELD = D212-664-101A
D212-682-021 LANDING GEAR WITH ARMOR SHIELD = D212-682-021A

*CUSTOMERS THAT REQUIRE THE SUPPORT BEAM ASSEMBLY ON 412 AIRCRAFT CAN PROCURE THE D412-682-001 SUPPORT BEAM KIT

E	ADD D212-682-011B/-111B	CP	09.03.30
D	ADD D212-682-111/-113 AND D412-682-001/-115/-117	PH	08.02.12
C	ADD -021/-025/-035, ADD ARMOR SHIELD	PH	06.10.26
B	ADD D412-682-015	DS	03.06.09
A	NEW ISSUE	DS	01.02.23
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	PH	DRAWING NO.	REV. E
MFG. APPR.	N/A	D212-682	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	LANDING GEAR KITS	NTS
DATE	09.03.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS ISSUED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	